

Work Order ID 64393

Friday, December 03, 2010 1:47:53 PM



Page 1

Item ID: D044-713-014

Accept



Setup Start,



Revision ID:

Item Name: Bubble Window, RH

Stop



Start Date: 12/3/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 12/17/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 10/12/3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A ITAD04-713	Rev N/A Rev A								
100	DOCUMENT CONTROL	0.00							
DC	Memo	0.00							
Document Control	Photocopy bluefiles and create labels per PPP D044-713-014 & DSI 9329								
	CHG002 CHG003 (windows are untrained).								
110	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									

Pb →

for BG 10-12-6
(3)

10/12/01 *(3)*

(3)

8/10/12/01

W/O: 64393		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/12/21	#100	Perm. change up Date (or at least add information) to header box Izn D044-713 Rev A.	BC	10.12.22			S 10/12/21
10/12/21	#100	update chg # to 003.	B	10.12.22			S 10/12/21

Part No: D044-713-014 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

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Revision ID:

Item Name: Bubble Window, RH

Stop

Start Date: 12/3/2010 Start Qty: 3.00

Required Date: 12/17/2010 Req'd Qty: 3.00

Cust Item ID:

Customer:



Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D044-713-014 Location: <u>91</u> PPP Rev: <u>C</u>								
140  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

cd/12/22 SP 30

10/12/22
cd10112122

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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RESEARCH DESIGN AND METHODS

Required Date: 12/17/2010

Required Qty: 3.00

Comments: IPP Rev:A 05.03.22 New issue KJ/JLM
IPP Rev:A 06-07-03 As per DSI 9329 JLM
IPP Rev:C 08-07-30 chg qty DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DT8720 		Manufactured	No			110	Each	0.0000	1	3			
template													
D2126 		Manufactured	No			110	f	115.1819	7.525	23.76316			
Seal (D2126 - 0903) cut to 90.3" MEASURE 5 1/2 x 20													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST405				115.1819211					
				48285				22.0884211					
				57106				93.0935					
D3269-2 		Manufactured	No			110	Each	0.0000	1	3			
Bubble Window, RH													
D3312-1 		Manufactured	No			110	Each	6.0000	1	3			
Placard													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST051				6					
				28101				6					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

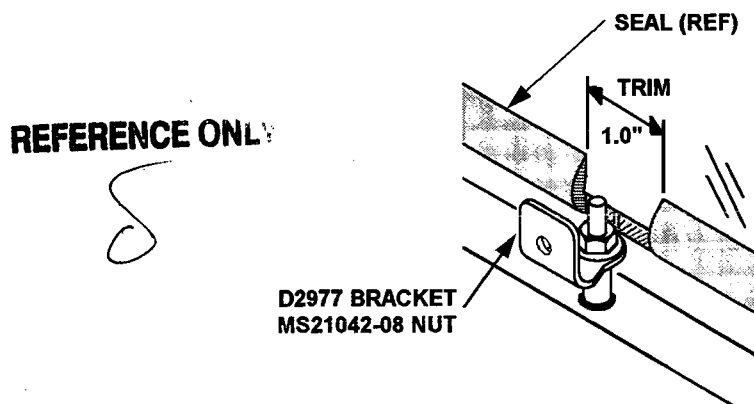


FIGURE 4 – D044-713-015 Passenger Door Window Kit – Tab Installation

4.0 WEIGHT AND BALANCE

The following are the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-713-011 Crew Door Window Kit	1.5 lb 0.68 kg	±24 in ±0.61 m	±36 in-lb ±0.43 m-kg	66 in 1.68 m	99 in-lb 1.1 m-kg
D044-713-013 Bubble Window Kit, LH	2.5 lb 1.1 kg	-28 in -0.71 m	-70 in-lb -0.78 m-kg	66 in 1.68 m	165 in-lb 1.8 m-kg
D044-713-014 Bubble Window Kit, RH	2.5 lb 1.1 kg	+28 in +0.71 m	+70 in-lb +0.78 m-kg	66 in 1.68 m	165 in-lb 1.8 m-kg
D044-713-015 Passenger Door Window Kit	1.2 lb 0.54 kg	±23 in ±0.58 m	±28 in-lb ±0.31 m-kg	83 in 2.11 m	100 in-lb 1.1 m-kg

5.0 PARTS LIST

Qty -011	Qty -013	Qty -014	Qty -015	Part Number	Description
X				D044-713-011	CREW DOOR WINDOW KIT, (FITS LH & RH)
	X			D044-713-013	BUBBLE WINDOW KIT, LH
		X		D044-713-014	BUBBLE WINDOW KIT, RH
			X	D044-713-015	PASSENGER DOOR WINDOW KIT, (FITS LH & RH)
			1	D2126-0720	SEAL
1	1	1		D2126-0903	SEAL
	1			D3269-1	BUBBLE WINDOW, LH
		1		D3269-2	BUBBLE WINDOW, RH
1				D3277-1	WINDOW
			1	D3279-1	WINDOW
	1	1		D3312-1	PLACARD
			1	D2977	BRACKET
			1	MS21042-08	NUT
*1	*1	*1		DT8720	D044-713-011/-013/-014 CUTTING TEMPLATE (FWD DOOR)
			*1	DT8721	D044-713-015 CUTTING TEMPLATE (AFT DOOR)

* Not to be installed. Cutting template only.

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Revision: **A**
Date: 05.01.10

DART

DESIGN QP	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED QP	APPROVED H	DRAWING NO. DSI 9329	REV. B SHEET 1 OF 1
DATE 06.06.26	TITLE BUBBLE WINDOW INSTALL MOD. SCALE NTS		
A	06.04.25	NEW ISSUE	
B	06.06.26	CHG TO EFFECTIVE AFTER CHG 002	

DART SERVICE INSTRUCTION
TO AMEND INSTALLATION INSTRUCTIONS IIN-D044-713 REV. A
REF. CANADIAN STC: SH05-13 ISSUE 1
REF. FAA STC: SR02088NY

REFERENCE ONLY

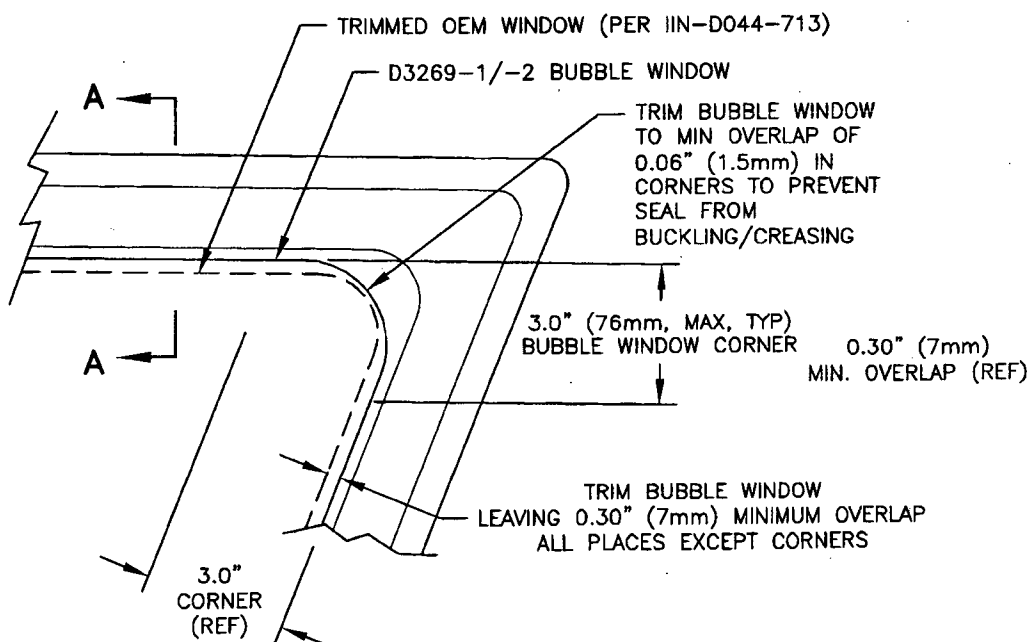
PURPOSE: For the D044-713-013/-014 kits supplied after CHG 002, the D3267-1/-2 bubble windows have been supplied untrimmed to allow for easier installation in the field. The installer must trim the windows in accordance with these instructions prior to installation.

PROCEDURE:

- 1) Modify the R44 crew door per items 3.2.1 and 3.2.2 of Installation Instructions IIN-D044-713 Rev.A.
- 2) Fit and trim the D3269-1/-2 Bubble Window to match the cutout in the door as follows: The bubble window must be a minimum of 0.30" (7mm) larger than the cutout in the OEM window as shown in the figure below. However, in the corners of the window, it is acceptable to trim a 0.06" minimum overlap (1.5mm) to help prevent the D2126-0903 Seal from buckling/creasing in the corners. The edge of the bubble window must be deburred to a smooth finish.
- 3) Continue installing the bubble window per items 3.2.3 through 3.2.5 of the installation instructions.

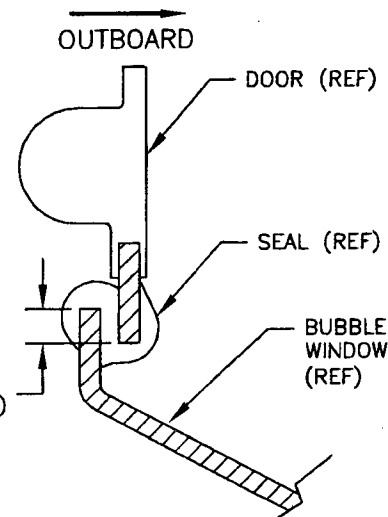
FIGURE 1

LOOKING AT INSIDE CORNER OF DOOR



SECTION A-A

(NOT TO SCALE)



CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 06.06.26
CERT. NO.: SH05-13
ISSUE NO.: 1

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